

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027117**Date Inspected:** 30-Jan-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steve Jensen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At the request of Quality Control Field Supervisor, Bonifacio Daquinag, QA has randomly verified the QC VT/MT of the Complete Joint Penetration (CJP) welding of three (3) bottom plate splice butt joints and four (4) lifting lug hole infill plates to top deck plate butt joints. The QA verification was performed to verify that the welding and the VT/MT inspection performed by the QC inspector meet the requirements of the contract documents. At the conclusion of the QA verification it appeared that the weld and the QC inspection complied with the contract documents.

1. OBG 12/13W bottom plate D1 inside - QA VT/MT verified
2. OBG 12/13W bottom plate D2 inside - QA VT/MT verified
3. OBG 12/13W bottom plate D3 inside - QA VT/MT verified
4. OBG 12W-PP115-W3#1 lifting lug hole outside - QA VT/MT verified
5. OBG 12W-PP115-W3#2 lifting lug hole outside - QA VT/MT verified
6. OBG 12W-PP115-W3#3 lifting lug hole outside - QA VT/MT verified
7. OBG 12W-PP115-W3#4 lifting lug hole outside - QA VT/MT verified

FW Spencer:

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## WELDING INSPECTION REPORT

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At location Panel Point PP32 to PP36 of OBG grid line W5, this QA randomly observed FW Spencer qualified welder Damian Llanos perform Complete Joint Penetration (CJP) 6G (all position) Shielded Metal Arc Welding (SMAW) welding root pass to cover pass on the 1" & 2" weldolet branch of the 2.5" and 4" domestic water and compressed air lines respectively. The system lines being welded are field weld joints along the grid line of W5 of the OBG. The welder was noted welding the root pass with 3/32" diameter E6010 electrode and followed by fill pass to cover pass using 3/32" diameter E7018H4R electrode implementing Caltrans approved procedure FW Spencer WPS 1-12-1. The welder was noted preheating and removing the moisture of the joint using a portable propane gas torch prior welding. During welding, ABF QC Steve Jensen was noted monitoring the parameters of the welder. At the end of the shift, three (3) weldolet field weld joints on each line (2 1/2" & 4") were completed and visually accepted by QC. This QA performed VT verification on the completed weld splices and they appear in compliance to the Contract requirements. The following were welded and inspected during the shift;

Line Service	Line Size	Weldolet Size	Panel Point	Location Joint Designation
1. Compressed Air	4" 2"	36	Northwest	1/CA2/36/NW
2. Domestic Water	2 1/2" 1'	36	Northwest	1/DW1/36/NW
3. Compressed Air	4" 2"	34	Northwest	1/CA2/34/NW
4. Domestic Water	2 1/2" 1'	34	Northwest	1/DW1/34/NW
5. Compressed Air	4" 2"	32	Northwest	1/CA2/32/NW
6. Domestic Water	2 1/2" 1'	32	Northwest	1/DW1/32/NW

### Summary of Conversations:

No significant conversation occurred today.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lizardo, Joselito	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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